

Work Order ID 61693

Tuesday, August 31, 2010 11:51:02 AM



Page 1

Item ID: D3637-041

Revision ID:

Item Name: Bracket Assembly

Start Date: 8/31/2010 Start Qty: 8.00

Required Date: 9/7/2010 Req'd Qty: 8.00

Reference:

Approvals:	Process Plan: 	Date: 20-8-81	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop		

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D3637	Rev B	

100



FLOW WATER JET

Waterjet

FLOW CNC Waterjet

304 . 080

Memo

1-Cut as per Dwg D3637 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

B10-9-8

(9)

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

B10-9-8

120



QC8- Inspect parts - second check

QC

Quality Control

Memo

0.00

S10/08/08

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan:

Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

Brake NC

Memo

Form as per Dwg D3637

140



Small Fab

0.00

Small Fab

Small Fab

Memo

1- drill holes as per dwg using DT8979□2-C'Sink as per Dwg D3637 □3-
Install Nut plate as per Dwg D3637

0.00

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

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Page 3

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Start Date: 8/31/2010 Start Qty: 8.00

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Reference:

Accept



Setup Start



Cust Item ID:



Customer:

Approvals: Process Plan: _____

Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
Description

160



Packaging

Packaging

244A

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

10/10/04 SF (90)

170



QC

Quality Control

QC21- Final Inspection Work Order Release

0.00

0.00

10/10/04 SF

MF
10-10-04

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Picklist Print

Tuesday, August 31, 2010 11:51:06 AM

Page 1

Work Order ID: 61693



Parent Item: D3637-041



Parent Item Name: Bracket Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:ec

Start Qty: 8.00

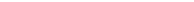
Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD3-3 Purchased No 100 Each 5,053.000 2 16

Rivet  

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	<u> </u>
ST316	5053		
19099	4774		

M304S14GA Purchased No 140 sf 106.8108 0.09 **0.757895**
  1210-9-8

304SS sheet .080

MS21059L4 Purchased No 140 Each 49.0000 1  8  *Eg 30/09/29*

<u>Location</u>	<u>Loc Oty</u>	<u>Loc Code</u>
ST301	30	
114718	30	
ST302	19	
112243	19	889

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DART AEROSPACE LTD	Work Order:	61493
Description: Bracket	Part Number:	D3637-1
Inspection Dwg: D3637	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>KB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: 10-9-08	Date: 10/09/08		Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	P/O D3637-041	KJ/DD  

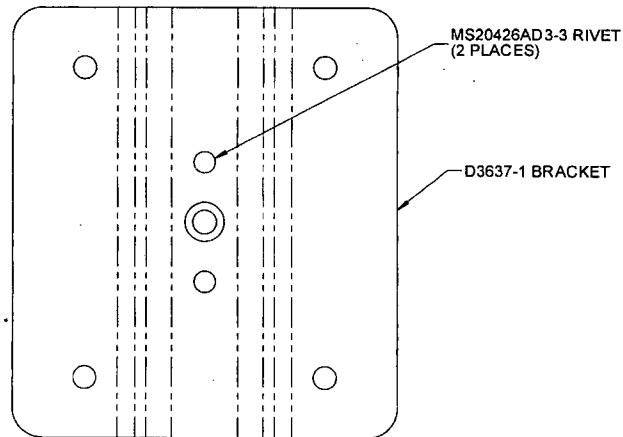
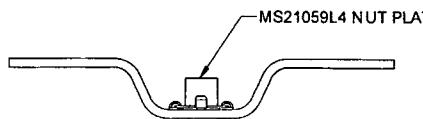
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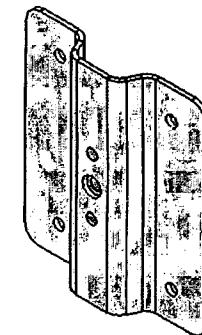
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D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61693
BH 10-8-31



D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

B	FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.18
A	NEW ISSUE: REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE LTD	
DRAWN	<i>TS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>TS</i>	REV. B	
MFG. APPR.	<i>TS</i>	SHEET 1 OF 3	
APPROVED	<i>TS</i>	SCALE	
DE APPR.	<i>TS</i>	BRACKET	1:1
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR COPIED OR DISCLOSED IN ANY OTHER FORM OR MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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NOTE: Date & initial all entries

8

7

6

5

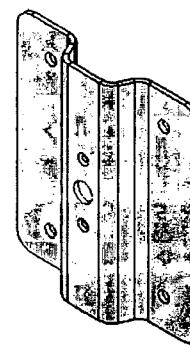
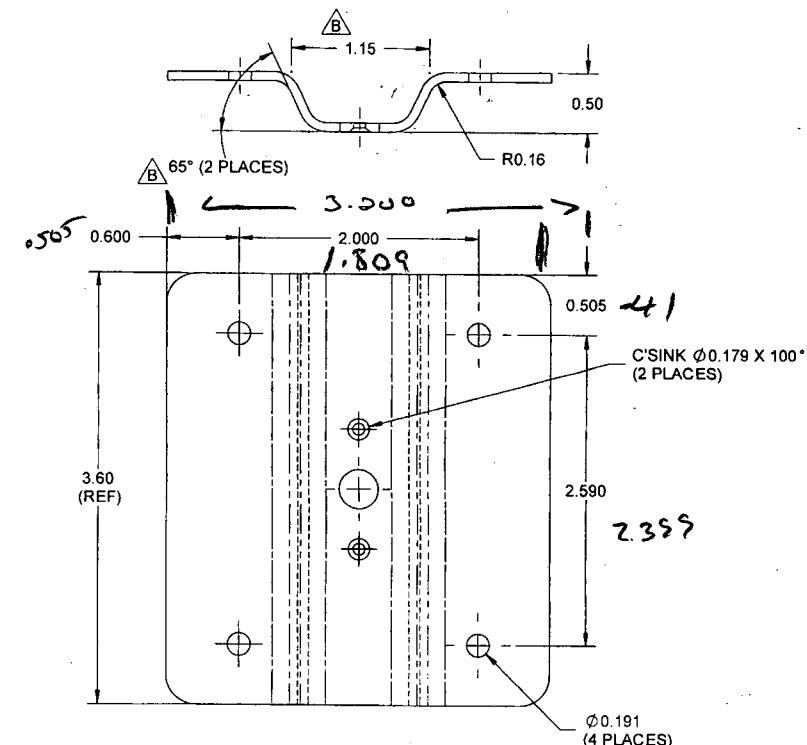
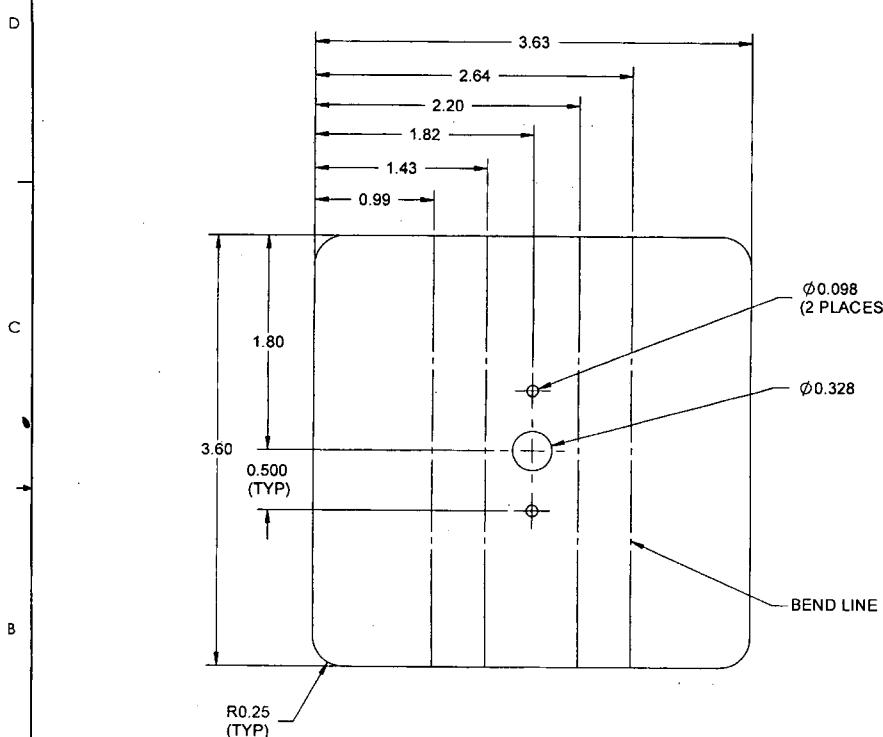
4

3

2

1

u061693



A D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059
(REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

8

7

6

5

4

3

2

1

DESIGN	TS	DART AEROSPACE LTD
DRAWN	<i>LE</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>RL</i>	DRAWING NO.
MFG. APPR.	<i>LG</i>	D3637
APPROVED	<i>LG</i>	REV. B
DE APPR.	<i>LG</i>	SHEET 2 OF 3
		TITLE
		SCALE
		1:1
DATE	07.12.18	

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RELEASED
06-02-05 TIP

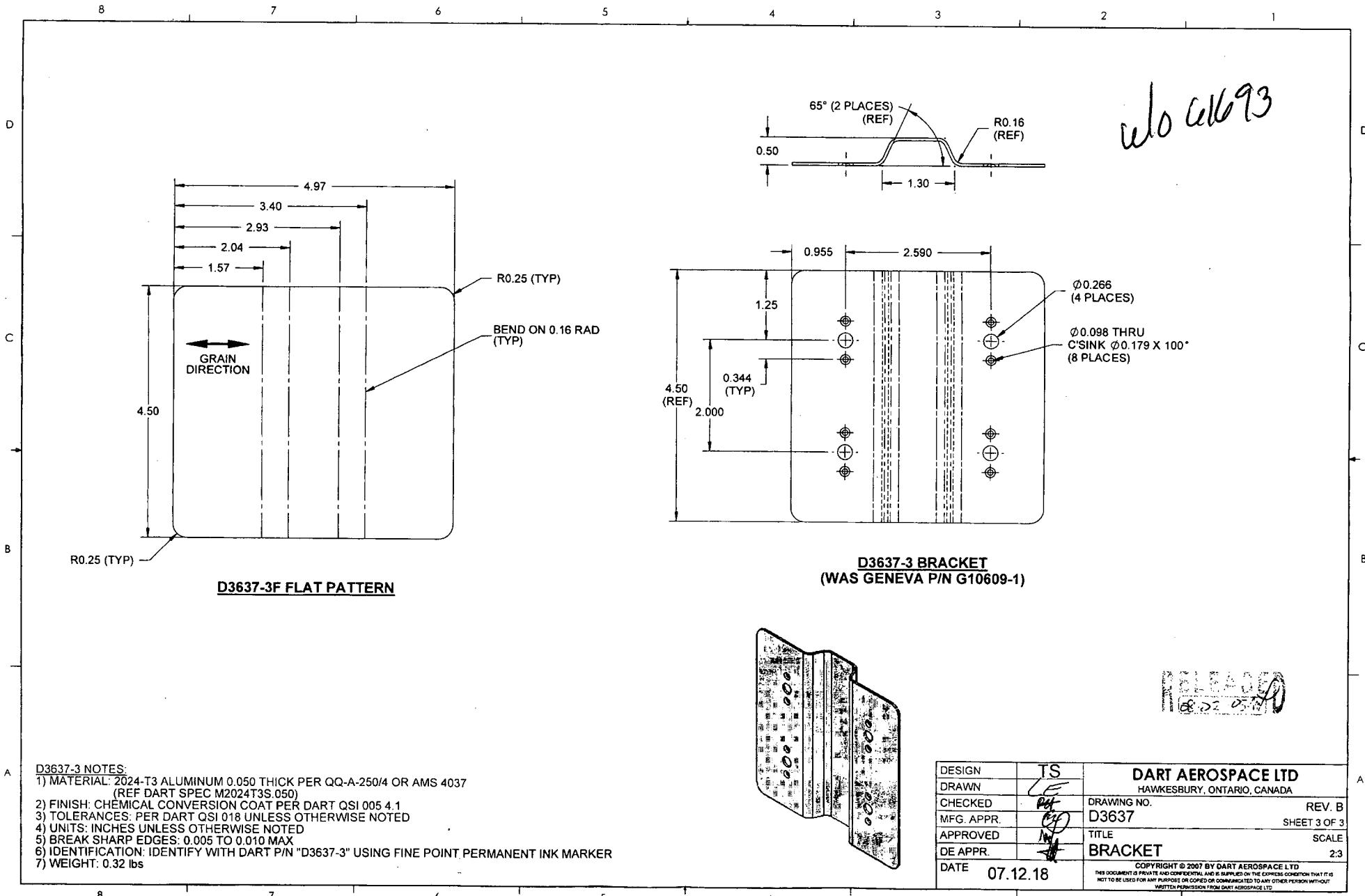
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